

Work Order ID 113414

Thursday, February 13, 2014 11:27:35 AM

113414

Page 1

Item ID: D4726-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Handle

Start Date: 2/13/2014 Start Qty: 20.00 *20* Cust Item ID:

Required Date: 2/13/2014 Req'd Qty: 20.00 *20* Customer:

Reference:

Approvals: Process Plan: MF Date: 14-2-13 Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4726	A

100	Cut blanks as per folio	0.00							
-----	-------------------------	------	--	--	--	--	--	--	--

1100

Bandsaw Memo 0.00

Jeaspa Bandsaw CUT BLANK AT 1.625"

110		0.00							
-----	--	------	--	--	--	--	--	--	--

1110

HAAS 1 Memo 0.00

HAAS CNC vertical machine #1 MACHINE AS PER DWG & FOLIO FB132

FOLIO REV: AA

DWG REV: A

DEBURR

20 0 14-02-24

20 0 14-02-24

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Page 2

Item ID: D4726-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Handle

Start Date: 2/13/2014 Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/13/2014 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
132	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
132									
Outsource4	Memo	0.00							
Outsource process - Anodize									

14-02-24

20

0

14/02/25

14-03-07

20

0

P/O. 23325

02

14/03/12

20

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Item ID: D4726-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle

Start Date: 2/13/2014 Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/13/2014 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

14-03-3114-03-31

Picklist Print

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Page 1

Work Order ID: 113414

113414

Parent Item: D4726-1

D4726-1

Parent Item Name: Handle

Start Date: 2/13/2014

Required Date: 2/13/2014

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X02.00 0		Purchased		No			f	12.0000		4			

M6061T6B0 750X02 000

6061-T6 Bar .750 x 2.00

3.083'

sf 14-02-24

Location

Loc Qty

Loc Code

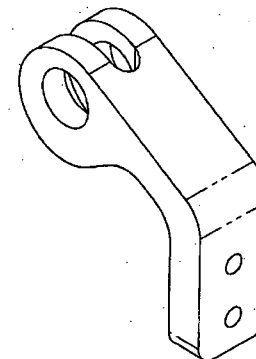
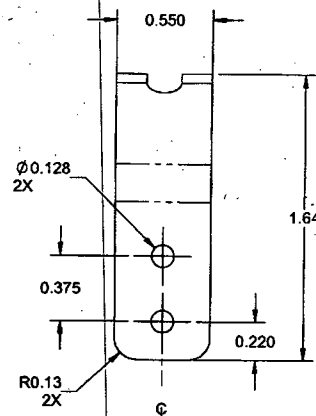
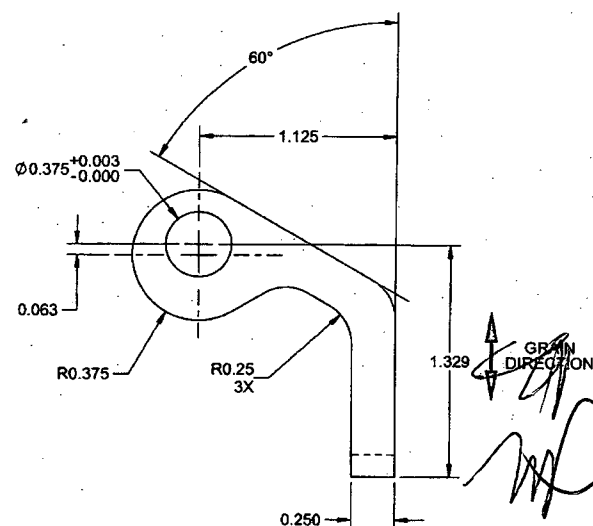
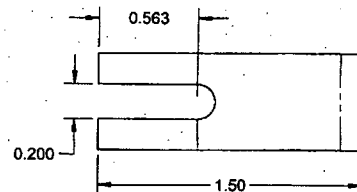
MAT001

12

m126647

12

3.083'



113414
mf
14-2-13

2012-10-12

D4726-1 HANDLE

NOTES:

- 1) MATERIAL: ALUMINUM, 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
- 2) FINISH: BLACK ANODIZE PER MIL-8625F, TYPE III, CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4726-1" AND B/N "BXXXXX" PER QSI 044 6.7
- 7) WEIGHT: 0.04 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DWG FILE "D4726-1-REVA.STP"

A		NEW ISSUE		RP	12.09.19
REV.		DESCRIPTION		BY	DATE
DESIGN	RP	DART AEROSPACE USA, INC. KENT, WA			
DRAWN	RP				
CHECKED	AP	DRAWING NO.	REV. A		
MFG. APPR.	<i>[Signature]</i>	D4726	SHEET 1 OF 1		
APPROVED	<i>[Signature]</i>	TITLE	SCALE		
DE APPR.	<i>[Signature]</i>	HANDLE	NTS		
DATE	12.09.19	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

DART AEROSPACE LTD		Work Order: 113 414
Description: Handle		Part Number: 04726-1
Inspection Dwg: 04726 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.563	+/- .010	.569	✓		SLO8	Vern
.200	+/- .010	.201	✓			
1.50	+/- .030	1.500	✓			
1.125	+/- .010	1.126	✓		Height gauge	
Ø.375	+ .003 / - 0.000	.377	✓		gauge Pin	
.063	+/- .010	.063	✓			
R.375	+/- .010	.375	✓		RAD GAUGE	
R.25	+/- .030	.250	✓			
.250	+/- .010	.249	✓			
1.329	+/- .010	1.329	✓		Height gauge	
.550	+/- .010	.548	✓			
Ø.128	+ .004 / - .001	.1295	✓		gauge Pin	
.375	+/- .010	.3735	✓			
R.13	+/- .030	.130	✓		Rad gauge	
.220	+/- .010	.219	✓		↓	
1.64	+/- .030	1.640	✓		Height gauge	

Measured by: <i>JS</i>	Audited by: <i>JS</i>	Preliminary Approval:
Date: 14-02-24	Date: 14-03-07	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

JS 10.04.15



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO23325**

Purchase Order Date 3/12/2014

PO Print Date 3/27/2014

Page Number 1 of 2

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone 613-446-4544

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

VENDOR'S TRUCK

FOB

FCA - (Free Carrier)

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	113414	D4726-1 HANDLE	3/31/2014		20.00	\$0.90	\$18.00
			Yes				
			3/31/2014				
	FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR IB/II/III CLASS 2						

Line Total: \$18.00

2	110625	646.2910 DEFLECTOR	3/31/2014		8.00	\$48.00	\$384.00
			Yes				
			3/31/2014				
	FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N						

Line Total: \$384.00

3	113624	646.2910 DEFLECTOR	3/31/2014		8.00	\$48.00	\$384.00
			Yes				
			3/31/2014				
	FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N						

Note:

3/27/2014



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62956

Date: 26-Mar-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 20 PCS D4726-1 (0.90) BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 16 PCS 646.2910 (48.00) HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PRICE IS PER PIECE Job: 20140191	Rev:	PO: 23325 Line:
<p>Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p>ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE : <u>26/3/14</u></p> <p>CERTIFIED SIGNATURE : <u>[Signature]</u></p> <p>RECEIVER SIGNATURE : _____</p>			